

Date: Thursday, 12/20/2007 3:16:06 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTER FWD SADDLE
Job Number : 36459	
Estimate Number : 11076	
P.O. Number : <u>N/A</u>	Part Number : D5951
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D5951 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35033	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 1/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:E Re-Format 05-11-29 JLM	

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 D6101013 Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: B 25357 (9) DJP 08/01/20 B25356 (1)

** Could not update*

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

SC/ SF 08/01/22

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SC/ SF 08/01/23

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ML 08/01/25 10

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML 08/01/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:16:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 36459

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 106379



(10)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 08-01-28

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ML



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-28

(X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

8/1/28

SD

(K0X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

PD 08/01/28

Job Completion



U 08-06-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36459
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.444	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.752	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.525	1.525		
I	3.048	3.058		3.054	3.054	3.054	3.055		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319		.319	.319	.319	.319		
L	0.495	0.505		.500	.500	.501	.501		
M	0.490	0.510		.510	.510	.507	.500		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		7.998	7.998	8.001	8.001		
P	2.240	2.260		2.242	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.495	.499	.500	.500		
T	1.375	1.395		1.388	1.385	1.387	1.388		
U	2.000	2.020		2.002	2.002	2.003	2.003		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	S.F.
Date:	08/01/23

Audited by:	Am
Date:	08/01/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36459
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	51	62	73	84		
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.525	1.525	1.525	1.525		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319		.319	.319	.319	.319		
L	0.495	0.505		.505	.505	.500	.500		
M	0.490	0.510		.507	.507	.507	.507		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.001	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.503	.503	.503	.503		
T	1.375	1.395		1.385	1.385	1.386	1.386		
U	2.000	2.020		2.000	2.000	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	08/01/23

Audited by:	RF
Date:	08/01/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
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DART AEROSPACE LTD		Work Order:	36459
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3	4		
A	0.437	0.444		.4410	.4410				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.750	5.750				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.318	.318				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.312	0.319		.317	.319				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.505	.505				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		8.003	8.003				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.311	.311				
R	0.760	0.765		.764	.764				
S	0.490	0.510		.502	.502				
T	1.375	1.395		1.386	1.386				
U	2.000	2.020		2.005	2.005				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BC
Date:	05.01.25

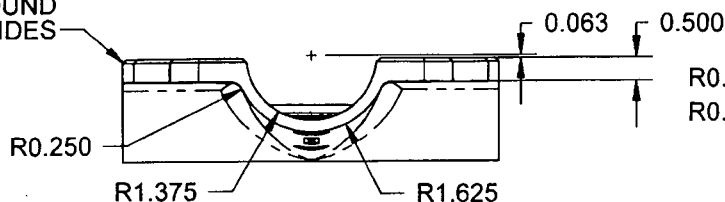
Audited by:	DMK
Date:	08/01/25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES



ENGRAVE PART NO.
AND BATCH NO.
WITH MIN RAD OF
0.010 TO MAX
DEPTH OF 0.010

R0.500
 $\phi 0.316$
(8 PLACES)

DRILL $\phi 0.316$ THRU
 $\phi 0.750$ SPOT FACE
(2 PLACES)

GRAIN
DIRECTION

ENGRAVE DART LOGO WITH
MIN RAD OF 0.250 TO MAX
DEPTH OF 0.015

R0.660
 $\phi 0.438$
(4 PLACES)

0.500

1.750

5.250

7.000

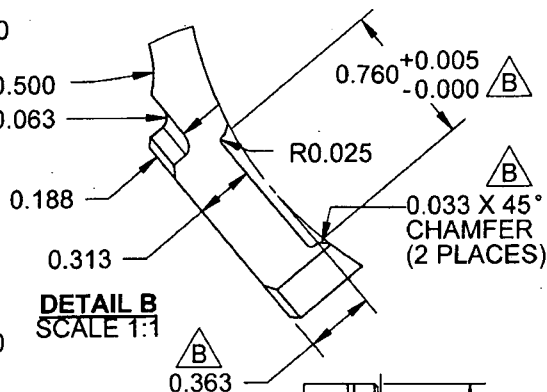
8.000

VIEW A-A

0.040 X 45° CHAMFER
ALL AROUND

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

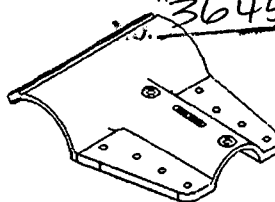


DETAIL B
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D5951 OUTER FWD SADDLE

WITHOUT NOTICE
WORK ORDER
36459



ISOMETRIC VIEW
SCALE 1:8

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